

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	:	206 L WEB
Job Number	: 34594			
Estimate Number	: 10722			
P.O. Number	: N/A	Part Number	:	D26547
This Issue	: 9/12/2007 S.O. No.	Drawing Number	:	D2654 REV E1
Prsht Rev.	: NC	Project Number	:	N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	:	E1
Previous Run	: 34509	Material	:	N/A
Written By	:	Due Date	:	9/30/2007 Qty:
Checked & Approved By	:			14 Um: Each
Comment	:			
	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM			
	: Est Rev:e 06.04.05 Added level21 EC			

Job Number:



1.0 D26007140 EXT. "I BEAM" THICK



Pick:

Qty	Part Number	Description	Batch
1	D2600-7- 140	Web	B-21966

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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1-Cut D2600-7 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-7 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM
07/09/18
(10)

JB 7-9-18 (4)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 15 Date: 07/29/19

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/12/2007 12:13:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L WEB

Job Number: 34594

Part Number: D26547

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DP 7-9-18

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LG*

Job 7-9-18

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(14)

Comment: FINAL INSPECTION/W/O RELEASE

DP 8/10/19

Job Completion



u 8/10/18

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

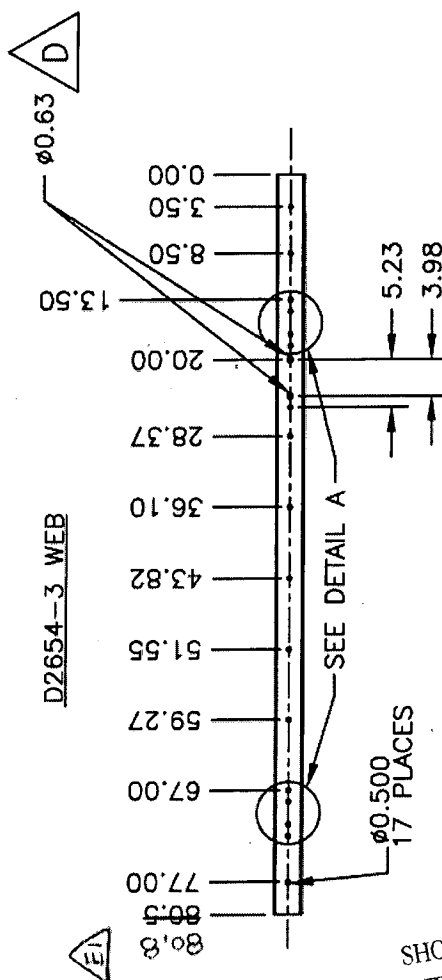
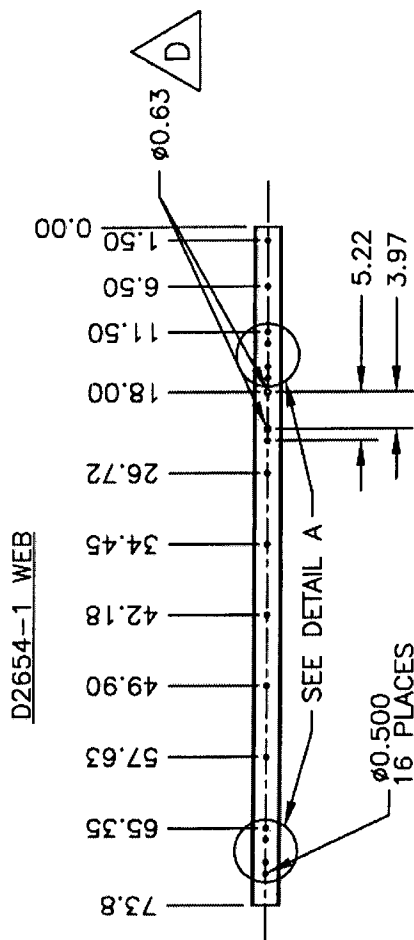
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE	
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29	CHANGED HOLE PATTERN	
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$	
E	04.05.26	CHANGE LENGTHS, REFORMAT	
E1 <i>CP</i>	<i>[Signature]</i> 04.08.24	PER TOOLING; 80.8 WAS 80.5	

RELEASED
04.06.22

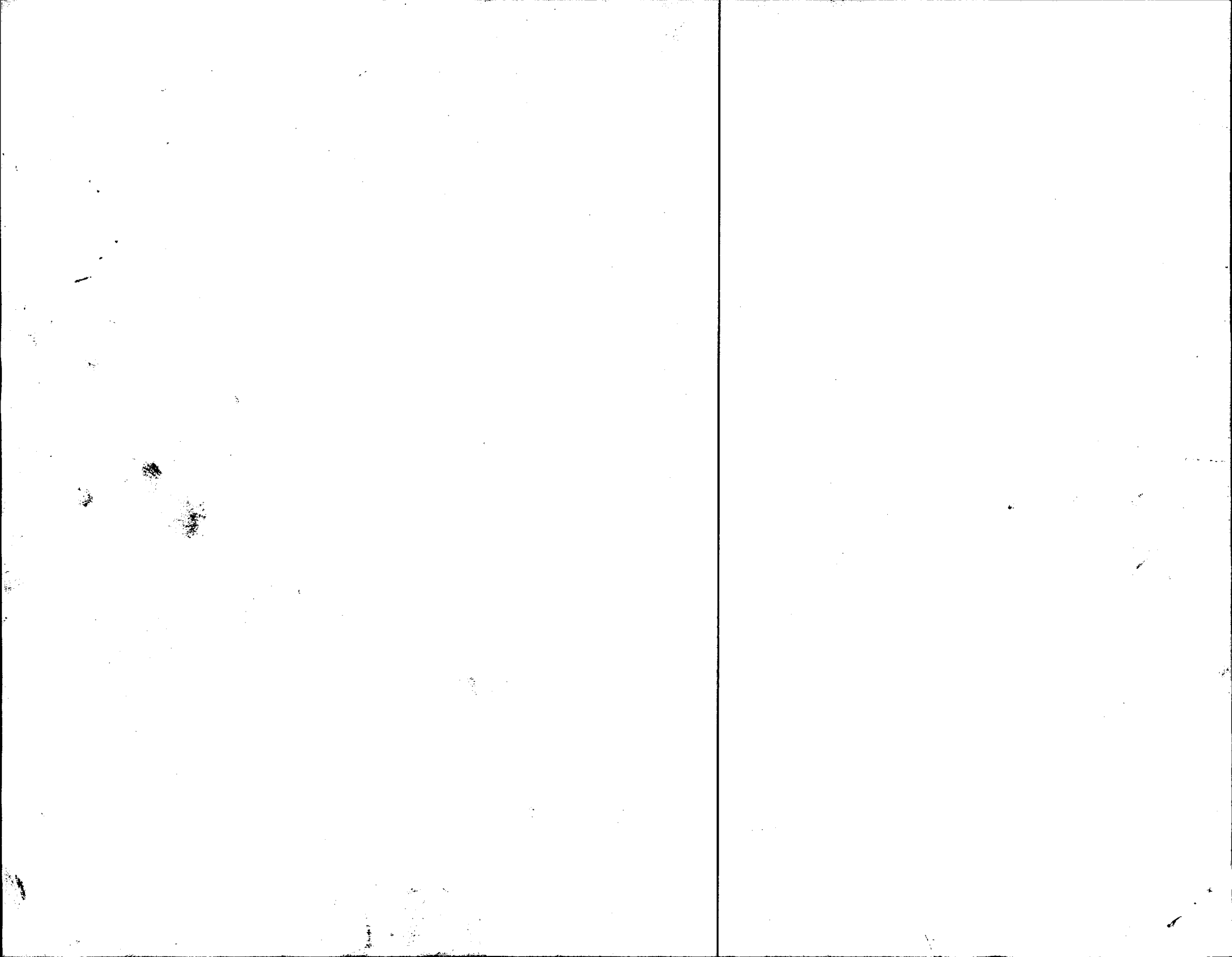


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WORK ORDER
NO. 34594

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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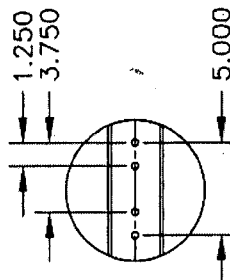




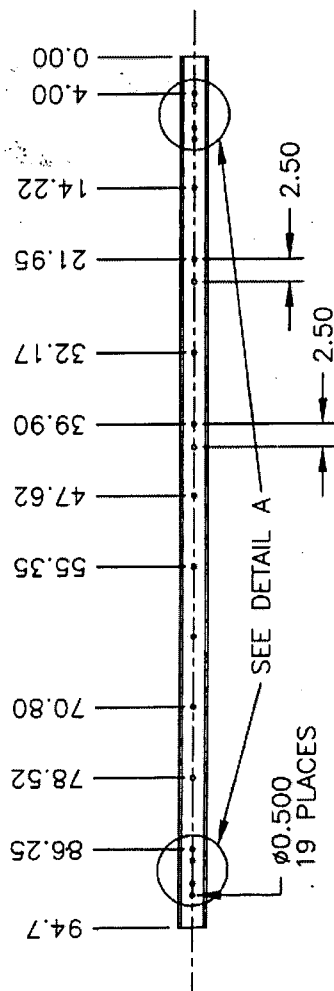
DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26	TITLE WEB		SCALE 1:20

RELEASED
04.06.22

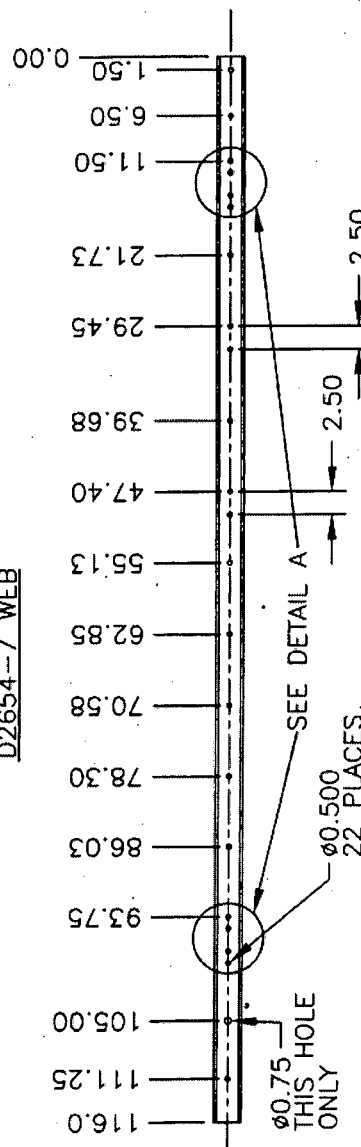
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION
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